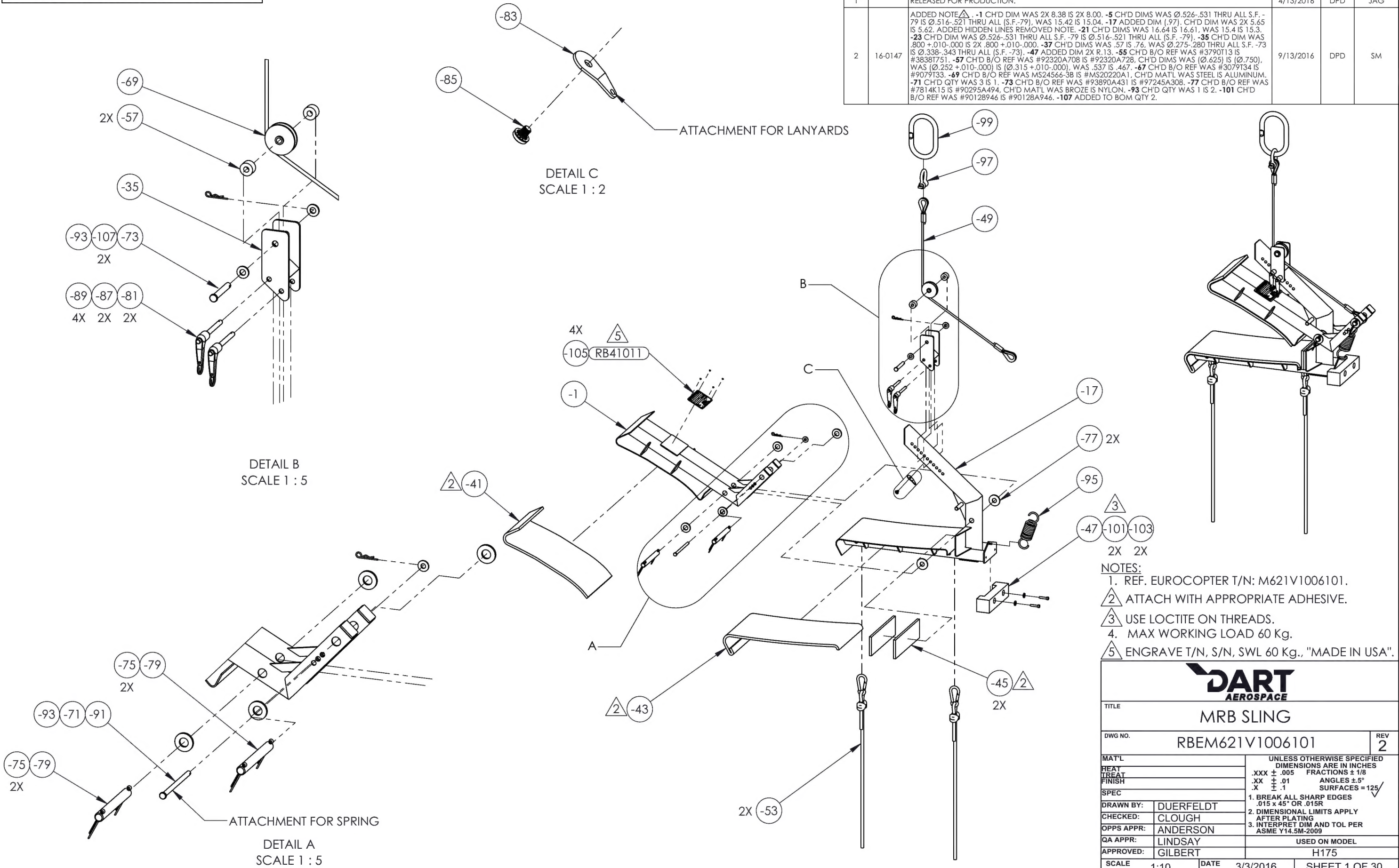


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REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		RELEASED FOR PRODUCTION.	4/13/2016	DPD	JAG
2	16-0147	ADDED NOTE: -1 CH'D DIM WAS 2X 8.38 IS 2X 8.00. -5 CH'D DIMS WAS Ø.526-.531 THRU ALL S.F. -79 IS Ø.516-.521 THRU ALL (S.F.-79), WAS 15.42 IS 15.04. -17 ADDED DIM (.97). CH'D DIM WAS 2X 5.65 IS 5.62. ADDED HIDDEN LINES REMOVED NOTE: -21 CH'D DIMS WAS 16.64 IS 16.61, WAS 15.4 IS 15.3. -23 CH'D DIM WAS Ø.526-.531 THRU ALL S.F. -79 IS Ø.516-.521 THRU ALL (S.F.-79). -35 CH'D DIM WAS .800 +.010-.000 IS 2X .800 +.010-.000. -37 CH'D DIMS WAS .57 IS .76, WAS Ø.275-.280 THRU ALL S.F. -73 IS Ø.338-.343 THRU ALL (S.F.-73). -47 ADDED DIM 2X R.13. -55 CH'D B/O REF WAS #3790T13 IS #3838T751. -57 CH'D B/O REF WAS #92320A708 IS #92320A728, CH'D DIMS WAS (Ø.625) IS (Ø.750), WAS (Ø.252 +.010-.000) IS (Ø.315 +.010-.000), WAS .537 IS .467. -67 CH'D B/O REF WAS #3079T34 IS #9079T33. -69 CH'D B/O REF WAS MS24566-3B IS #MS20220A1, CH'D MAT'L WAS STEEL IS ALUMINUM. -71 CH'D QTY WAS 3 IS 1. -73 CH'D B/O REF WAS #93890A431 IS #97245A308. -77 CH'D B/O REF WAS #7814K15 IS #90295A494, CH'D MAT'L WAS BROZE IS NYLON. -93 CH'D QTY WAS 1 IS 2. -101 CH'D B/O REF WAS #90128946 IS #90128A946. -107 ADDED TO BOM QTY 2.	9/13/2016	DPD	SM



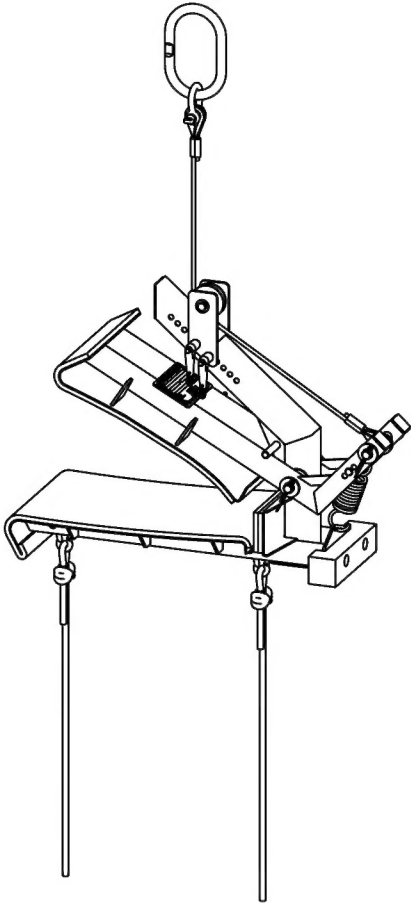
- NOTES:
1. REF. EUROCOPTER T/N: M621V1006101.
 2. ATTACH WITH APPROPRIATE ADHESIVE.
 3. USE LOCTITE ON THREADS.
 4. MAX WORKING LOAD 60 Kg.
 5. ENGRAVE T/N, S/N, SWL 60 Kg., "MADE IN USA".


DART AEROSPACE		
TITLE MRB SLING		
DWG NO. RBEM621V1006101	REV 2	
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	
DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	DUERFELDT CLOUGH ANDERSON LINDSAY GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:10		USED ON MODEL H175
DATE 3/3/2016		SHEET 1 OF 30

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

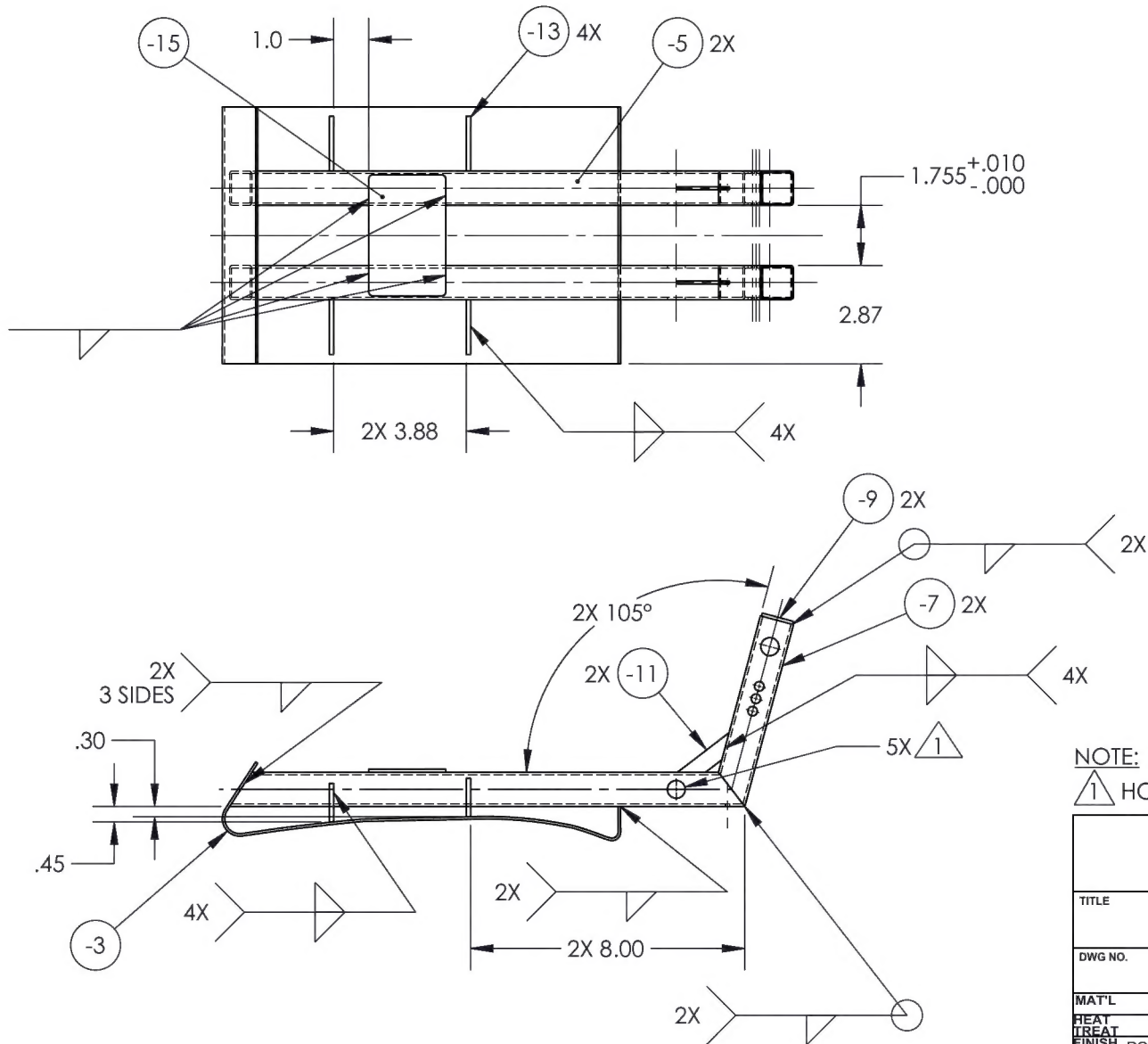
ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
				X		-1	1	TOP WELDMENT			3
				1		-3		TOP CLAMP	A36/1018/1020 HR		4
				2		-5		TOP LONG TUBE	STEEL TUBE		5
				2		-7		TOP SHORT TUBE	STEEL TUBE		6
				2		-9		TUBE CAP	A36/1018/1020 HR		7
				2		-11		TOP TUBE TO TUBE BRACE	A36/1018/1020 HR		8
			6	4		-13		CLAMP TO TUBE BRACE	A36/1018/1020 HR		9
			1	1		-15		RECTANGLE TUBE BRACE	A36/1018/1020 HR		10
			X			-17	1	BOTTOM WELDMENT			11
			1			-19		BOTTOM CLAMP	A36/1018/1020 HR		12
			2			-21		BOTTOM TUBE	STEEL TUBE		13
			1			-23		BOTTOM UPRIGHT TUBE	STEEL TUBE		14
			1			-25		BOTTOM ANGLE TUBE	STEEL TUBE		15
			1			-27		BOTTOM SPRING ANCHOR PLATE	A36/1018/1020 HR		16
			1			-29		STOP GUSSET	A36/1018/1020 HR		17
			1			-31		BOTTOM UPRIGHT SUPPORT	A36/1018/1020 HR		18
			1			-33		LARGE TUBE CAP	A36/1018/1020 HR		19
		X				-35	1	LIFTING BLOCK WELDMENT			20
		2				-37		LIFTING BLOCK PLATE	1018/1020 CR		21
		1				-39		LIFTING BLOCK SPACER	1018/1020 CR		22
						-41	1	TOP CLAMP PAD	NEOPRENE/EPDM/SBR FOAM	1/4 X 42 WIDE, SOFT (MCMASTER-CARR #8647K33) MODIFIED	23
						-43	1	BOTTOM CLAMP PAD	NEOPRENE/EPDM/SBR FOAM	1/4 X 42 WIDE, SOFT (MCMASTER-CARR #8647K33) MODIFIED	24
						-45	2	BACK FOAM PAD	NEOPRENE/EPDM/SBR FOAM	1/4 X 42 WIDE, SOFT (MCMASTER-CARR #8647K33) MODIFIED	25
						-47	1	REAR BUMPER	URETHANE, 60A	(MCMASTER-CARR #8644K24) MODIFIED	26
	X					-49	1	LIFTING CABLE ASSEMBLY			27
	1					-51		LIFTING CABLE	STEEL	Ø3/16, 6 X 19, 760 LBS CAPACITY (MCMASTER-CARR #3440T55) MODIFIED	27
X						-53	2	ROPE & CARABINER ASSEMBLY			28
1						-55		ROPE	ARAMID	Ø5/16 (MCMASTER-CARR #3838T751) MODIFIED	28
						-57	2	SPACER	S.S.	Ø5/16 I.D. X Ø3/4 O.D. X 5/8 (MCMASTER CARR #92320A728) MODIFIED	29
			1		B/O	-59		DOWEL PIN	STEEL	Ø3/8 X 3-1/2 (MCMASTER-CARR #98381A638)	11
			2		B/O	-61		DOWEL PIN	STEEL	Ø5/16 X 3-1/2 (MCMASTER-CARR #98381A598)	11
	2				B/O	-63		LIFTING THIMBLE	STEEL	11/16 X 1-5/16, Ø3/16 CABLE (MCMASTER-CARR #3494T12)	27
	2				B/O	-65		LIFTING OVAL SLEEVE	S.S.	Ø3/16 ROPE X 1 (MCMASTER-CARR #3755T17)	27
1					B/O	-67		CARABINER	STEEL	Ø5/16 THICK X Ø1/2 X 2-1/2, 3/8 OPENING (MCMASTER-CARR #3079T33)	28
					B/O	-69	1	PULLEY	ALUMINUM	Ø1.755 O.D. X Ø1.255 GROOVE, Ø3/16 CABLE (MS20220A1)	1
					B/O	-71	1	WASHER	S.S.	Ø1/4 (MCMASTER-CARR #92141A029)	1
					B/O	-73	1	CLEVIS PIN	STEEL	Ø5/16 X 2 USABLE (MCMASTER-CARR #97245A308)	1
					B/O	-75	4	WASHER	STEEL	Ø1/2 (MCMASTER-CARR #98023A033)	1
					B/O	-77	2	THRUST BEARING	NYLON	Ø1/2 I.D. X Ø1.25 O.D. X .093-.107 (MCMASTER-CARR #90295A494)	1
					B/O	-79	2	HEADLESS CLEVIS PIN	STEEL	Ø1/2 X 4 USABLE (MCMASTER-CARR #93890A499)	1
					B/O	-81	2	L HANDLE BALL LOCK PIN	S.S.	Ø1/4 X 2 USABLE (MCMASTER-CARR #90302A114)	1
					B/O	-83	1	LANYARD TAB	ALUMINUM	#10 (CARR-LANE #CL-194-TAB-A)	1
					B/O	-85	1	PAN HEAD MACHINE SCREW	STEEL	10-32 X 1/4 (MCMASTER-CARR #90403A823)	1
					B/O	-87	2	LANYARD	COATED STEEL	Ø1/16 X 12 (CARR LANE #CL-2-C)	1
					B/O	-89	4	FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMASTER-CARR #3896T31)	1
					B/O	-91	1	CLEVIS PIN	S.S.	Ø1/4 X 3-13/16 USABLE (MCMASTER-CARR #92390A184)	1
					B/O	-93	2	HAIR PIN	S.S.	Ø1/4 - Ø1/2 PIN, Ø1/16 WIRE (MCMASTER-CARR #92391A120)	1
					B/O	-95	1	EXTENSION SPRING	S.S.	Ø.148 WIRE X Ø1.25 O.D. X 4, 37 LBS/IN (CENTURY SPRING #81130S)	1
					B/O	-97	1	SHACKLE	STEEL	Ø5/16, 1500 WLL (MCMASTER-CARR #3558T46)	1
					B/O	-99	1	OBLONG RING	S.S.	Ø1/2 X 2-3/8 X 4-1/4 (MCMASTER-CARR #30765T85)	1
					B/O	-101	2	SOCKET HEAD CAP SCREW	STEEL	#10-32 X 7/8 (MCMASTER-CARR #90128A946)	1
					B/O	-103	2	WASHER	STEEL	#10 (MCMASTER-CARR #98023A114)	1
					B/O	-105	4	#2 DRIVE SCREW	COATED STEEL	#2 X 1/8 (MCMASTER-CARR #90081A074)	1
					B/O	-107	2	WASHER	STEEL	Ø5/16 (MCMASTER-CARR #98023A030)	1
					B/O		1	DART PLACARD	ALUMINUM	RB41011	1
ASSY -53	ASSY -49	ASSY -35	ASSY -17	ASSY -1							



			
TITLE			
MRB SLING			
DWG NO.			REV
RBEM621V1006101			2
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ±.5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY:		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR:		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:		USED ON MODEL	
APPROVED:		H175	
SCALE		DATE	
1:10		3/3/2016	SHEET 2 OF 30

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-1 CH'D DIM WAS 2X 8.38 IS 2X 8.00.	9/13/2016	DPD	JAG



NOTE:

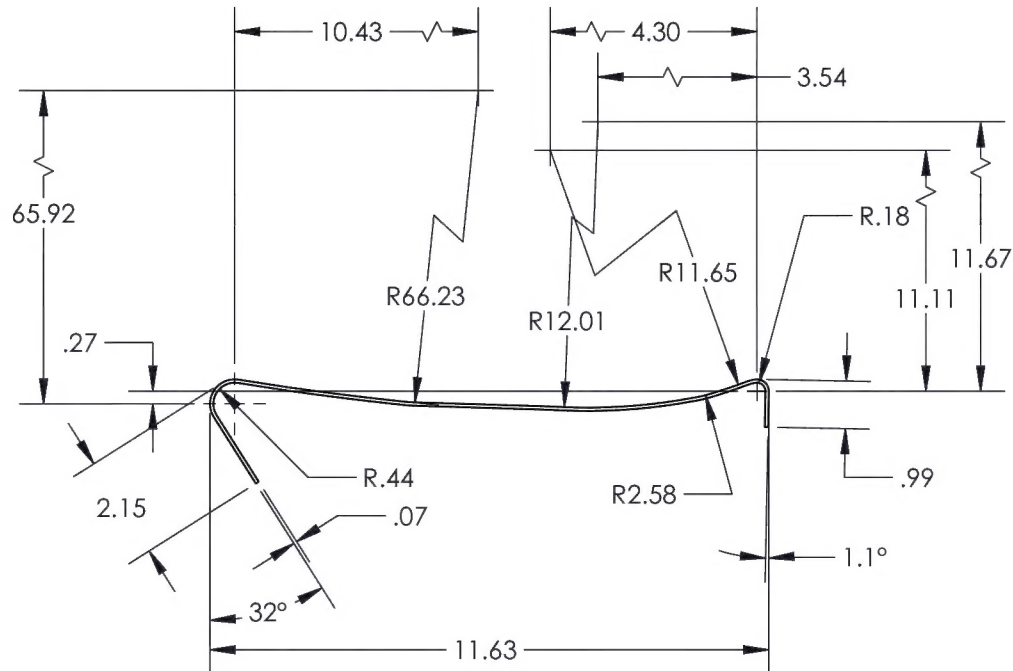
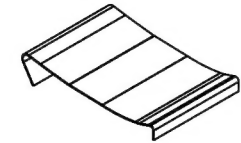
1 HOLES MUST ALIGN.

(-1)
TOP WELDMENT

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-1	REV 2
MAT'L REAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 3/3/2016 SHEET 3 OF 30

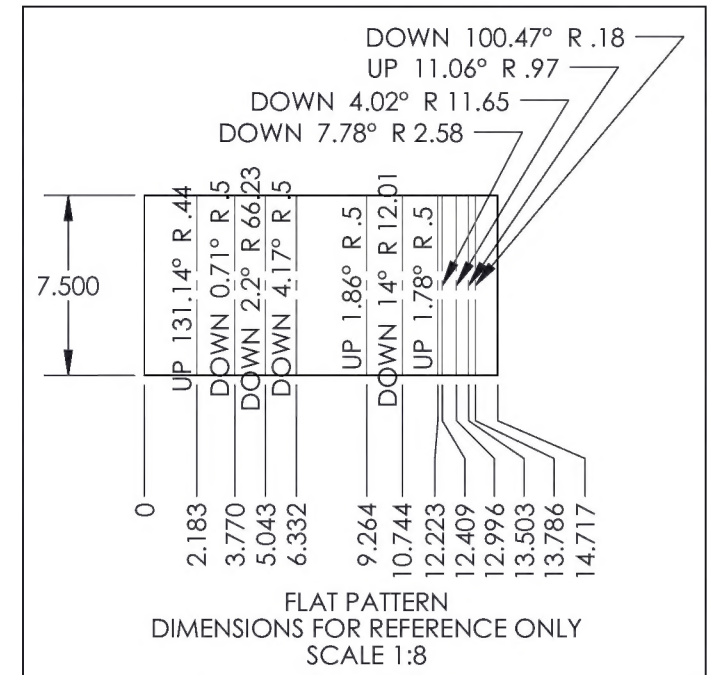
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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



(-3)

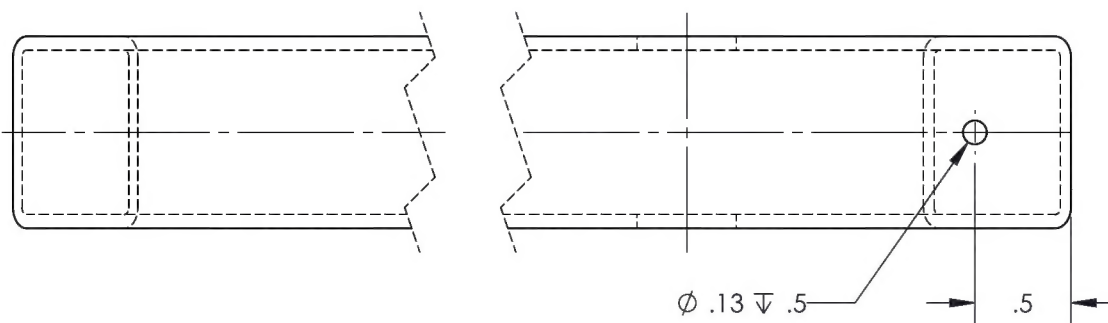
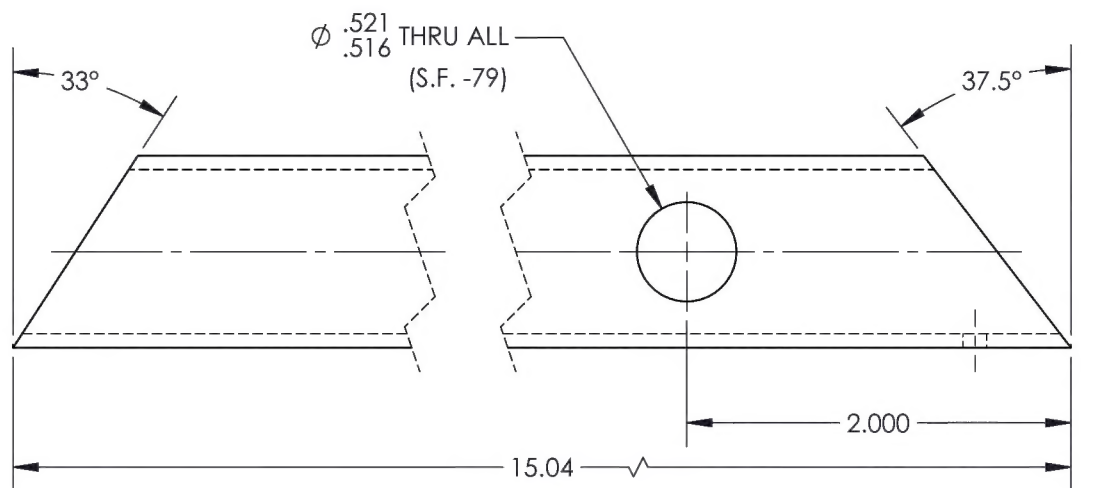
TOP CLAMP



TITLE		MRB SLING	
DWG NO.		RBEM621V1006101-3	
REV		2	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -1		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: DUERFELDT		.X ± .1 SURFACES = 125/✓	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:4		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/3/2016		USED ON MODEL	
SHEET 4 OF 30		H175	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	16-0147	-5 CH'D DIMS WAS Ø.526-.531 THRU ALL S.F. -79 IS Ø.516-.521 THRU ALL (S.F.-79), WAS 15.42 IS 15.04.			9/13/2016	DPD	SM



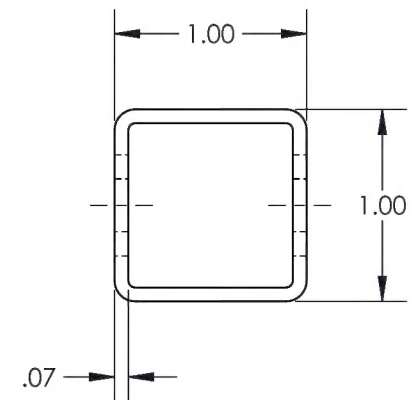
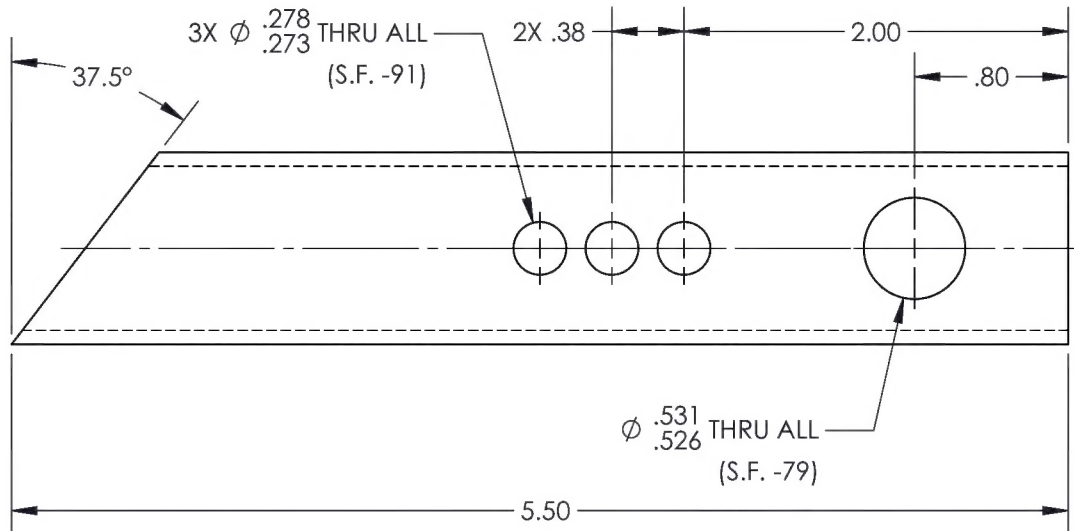
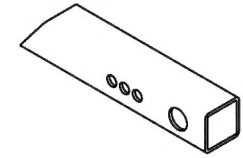
(5)

TOP LONG TUBE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-5	REV 2
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL H175
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 3/3/2016
SHEET 5 OF 30	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

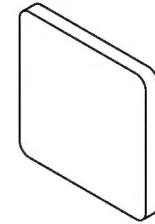
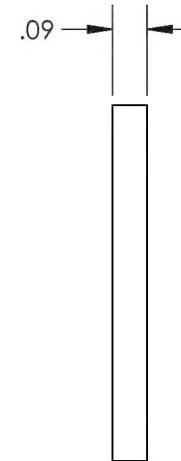
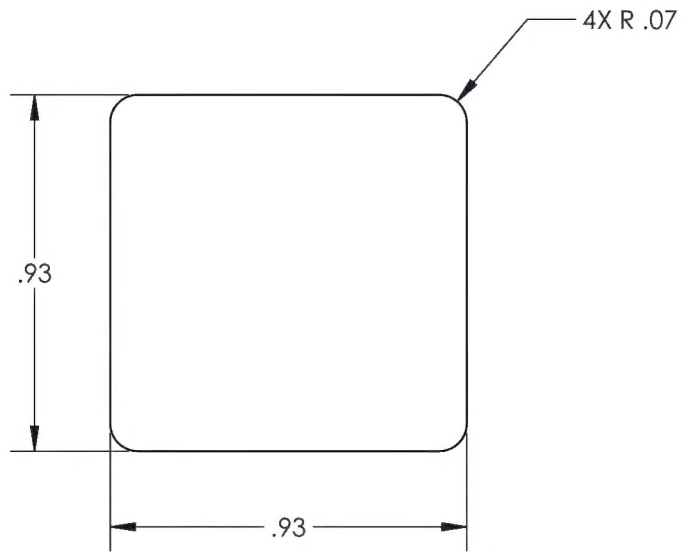


(-7)
TOP SHORT TUBE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-7	REV 2
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/3/2016
	SHEET 6 OF 30

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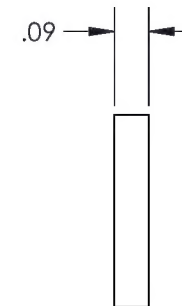
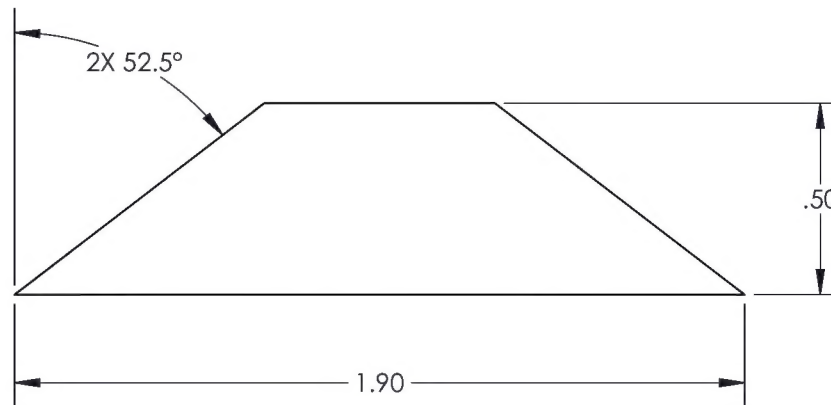
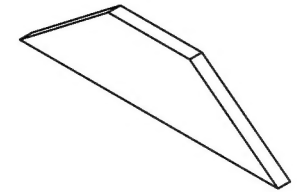


(-9)
TUBE CAP

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-9	REV. 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 3/3/2016
	SHEET 7 OF 30

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



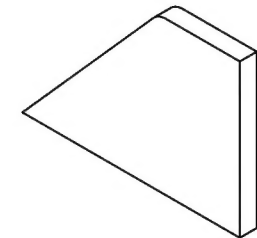
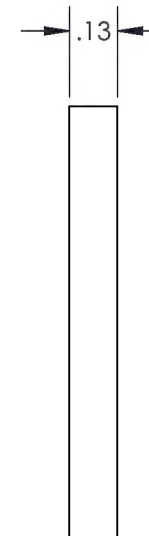
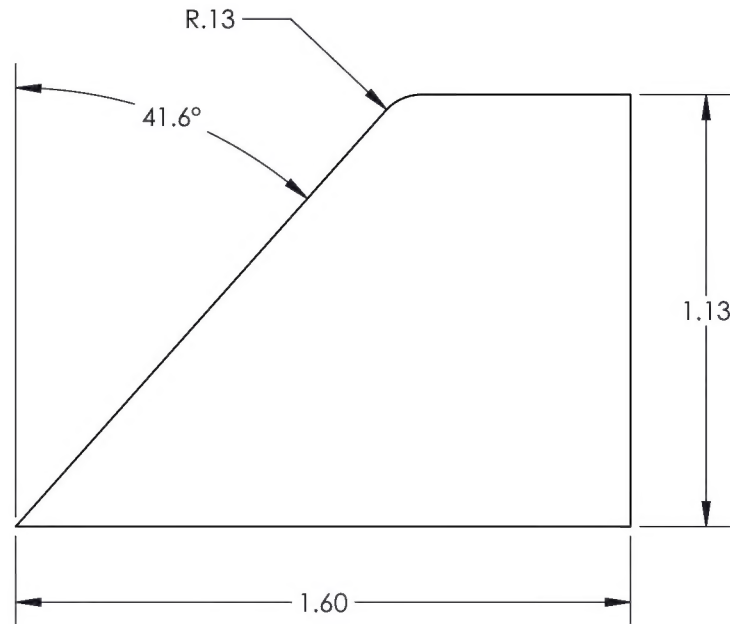
(-11)

TOP TUBE TO TUBE BRACE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-11	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 3/3/2016
	SHEET 8 OF 30

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



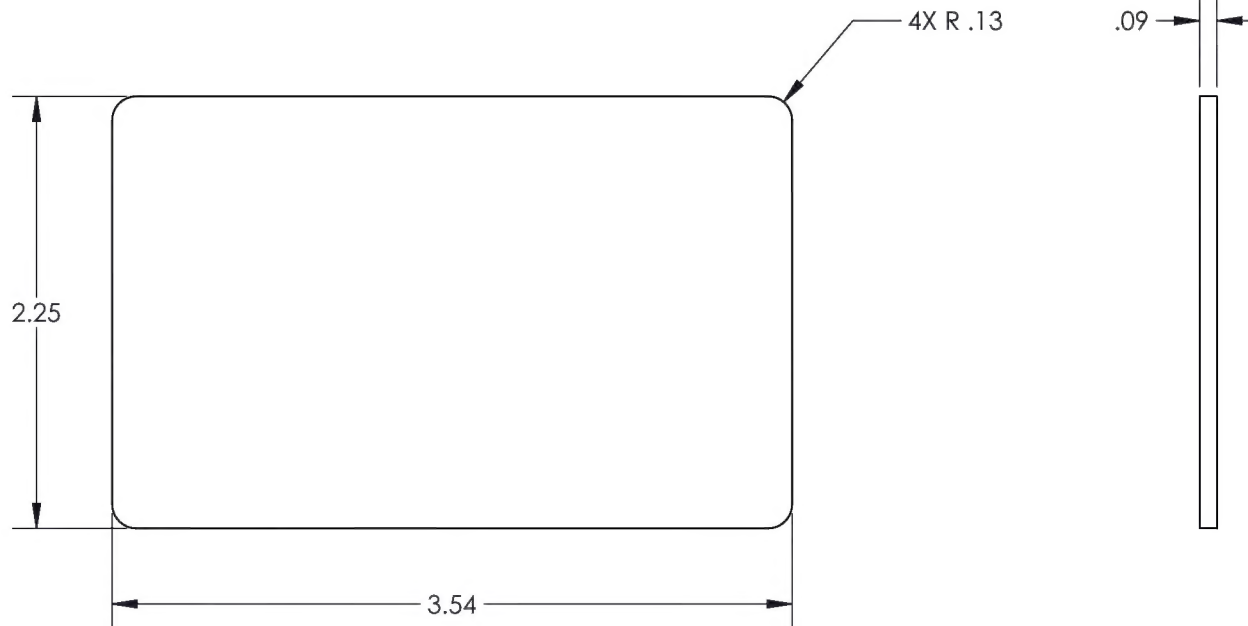
(-13)

CLAMP TO TUBE BRACE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-13	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 & -17	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 3/3/2016
	SHEET 9 OF 30

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



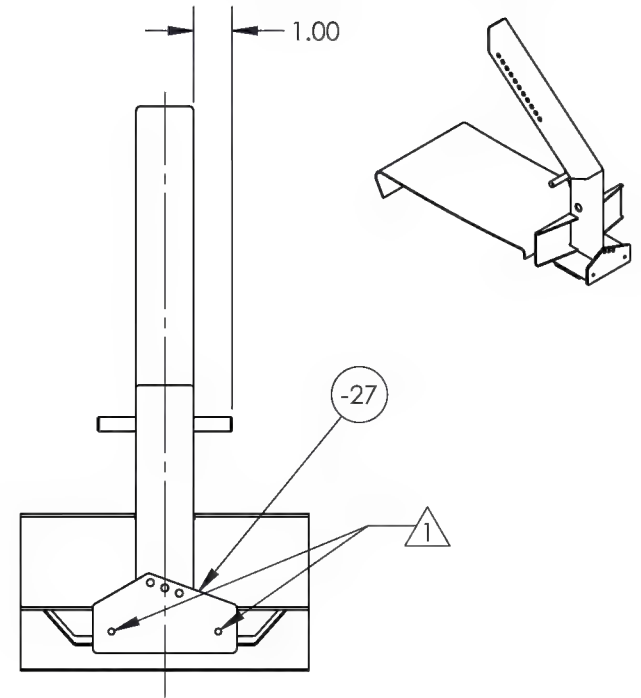
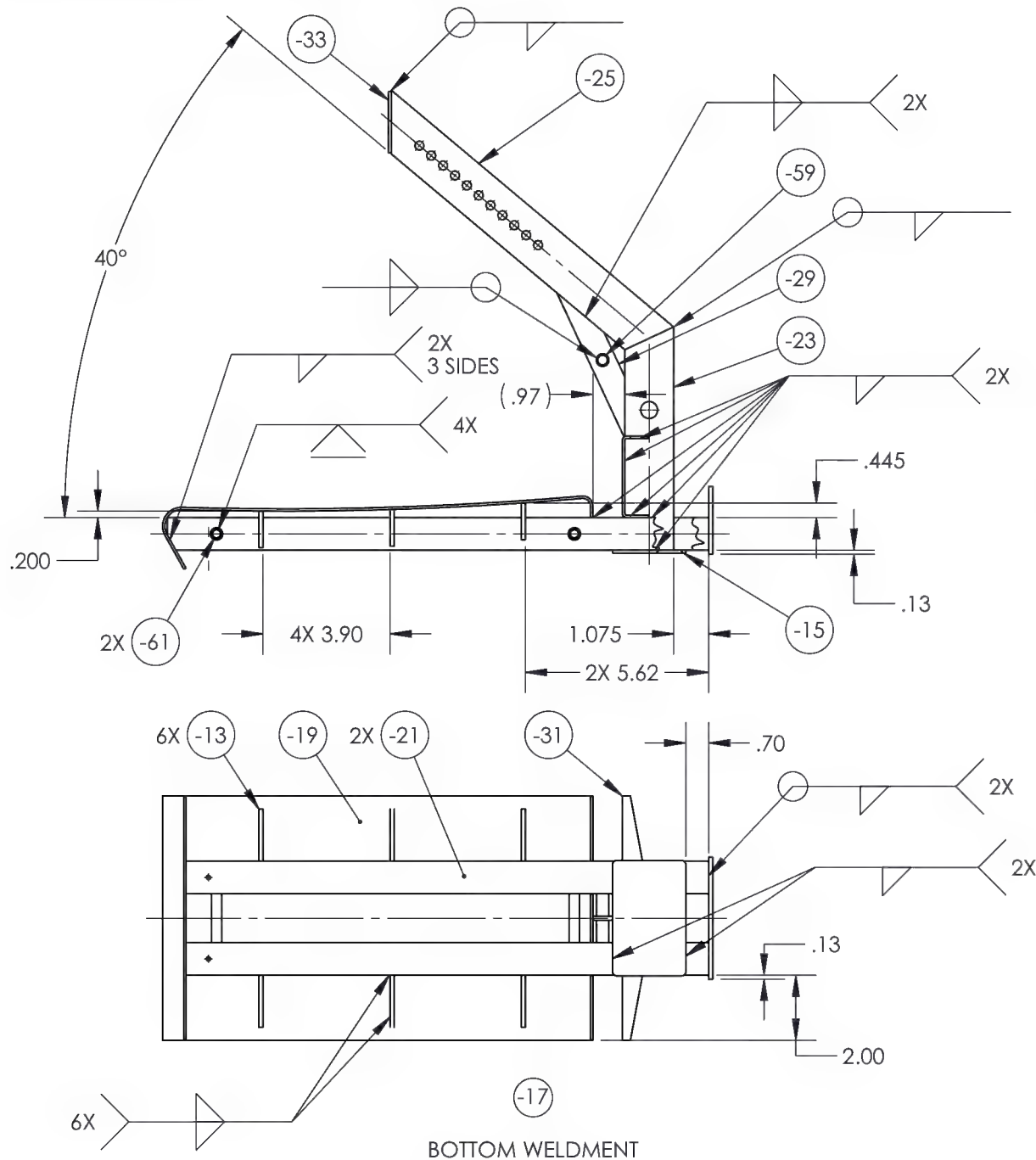
TITLE		MRB SLING	
DWG NO.		RBEM621V1006101-15	
		REV 2	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -1 & -17		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: DUERFELDT		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
		USED ON MODEL	
		H175	
SCALE	1:1	DATE	3/3/2016
		SHEET 10 OF 30	

-15

RECTANGLE TUBE BRACE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-17 ADDED DIM (.97). CH'D DIM WAS 2X 5.65 IS 5.62. ADDED HIDDEN LINES REMOVED NOTE.	9/13/2016	DPD	SM



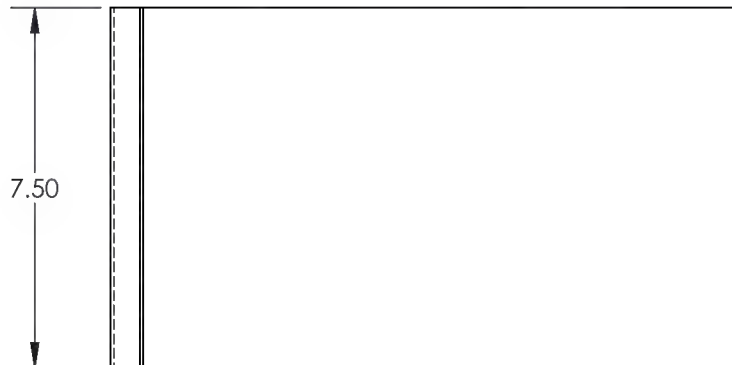
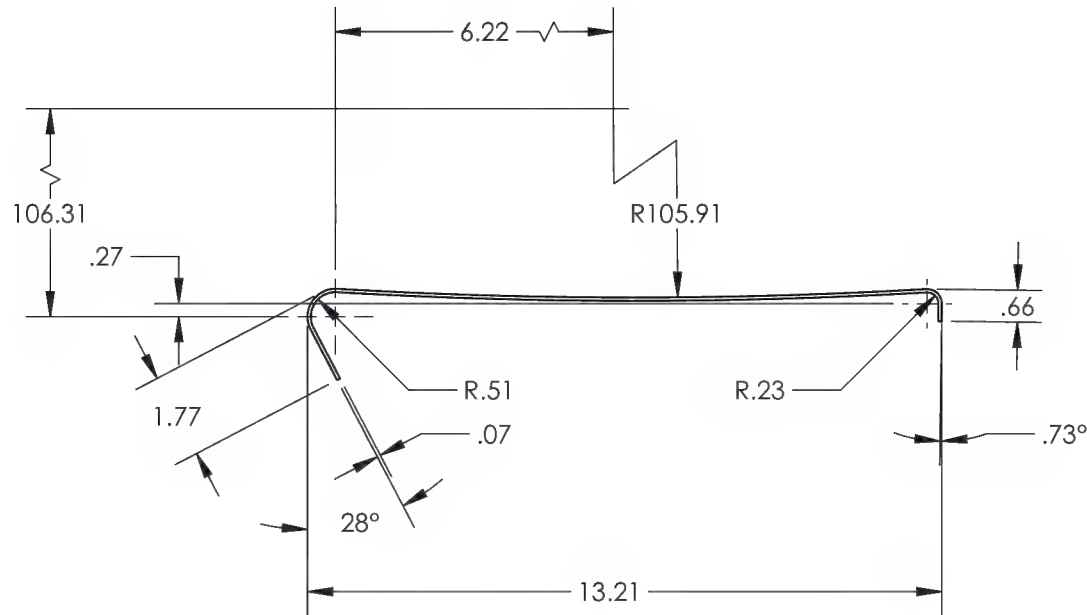
NOTE:

1. NO POWDER COAT IN THREADS.
2. HIDDEN LINES OMITTED FOR CLARITY.

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-17	REV 2
MAT'L HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL H175
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 3/3/2016
SHEET 11 OF 30	

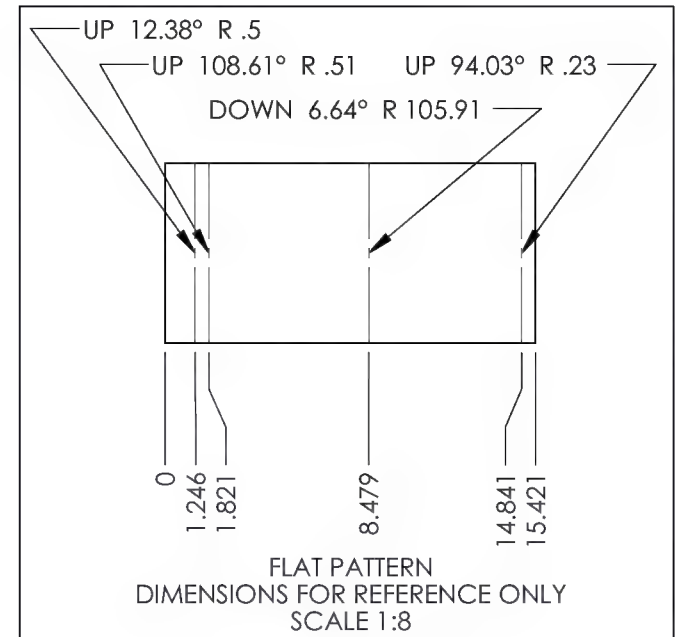
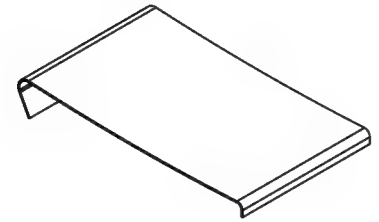
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL



-19

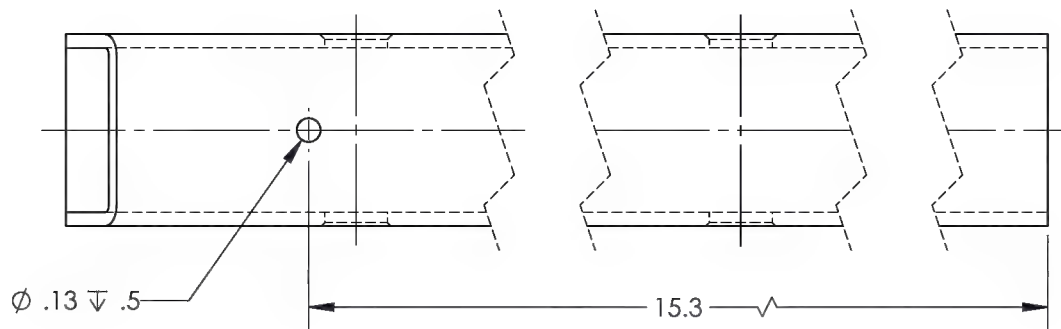
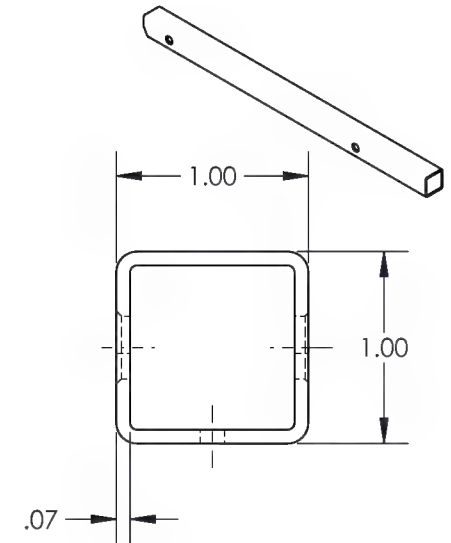
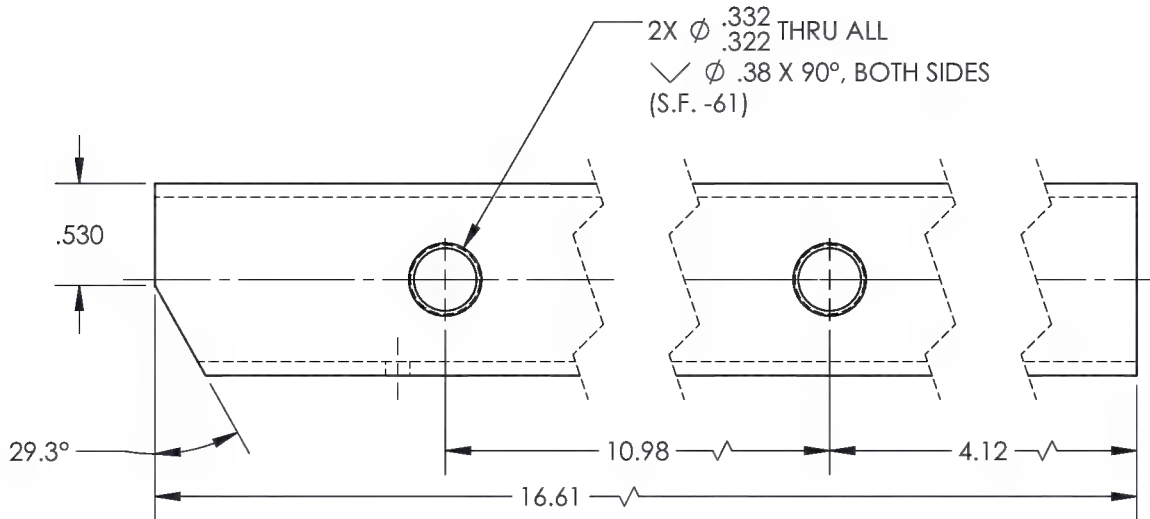
BOTTOM CLAMP



DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-19	REV 2
MAT'L A36/1018/1020 HR HEAT TREAT FINISH SEE -17 SPEC DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL H175	
SCALE 1:4	DATE 3/3/2016
SHEET 12 OF 30	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-21 CH'D DIMS WAS 16.64 IS 16.61, WAS 15.4 IS 15.3.	9/13/2016	DPD	JAG



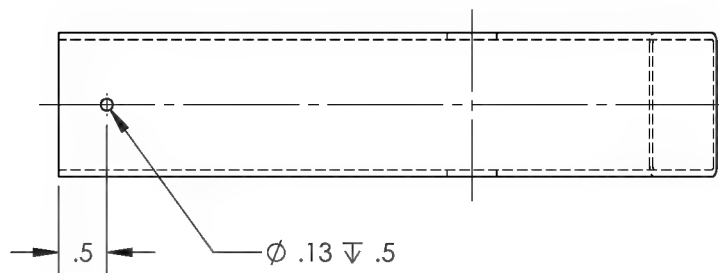
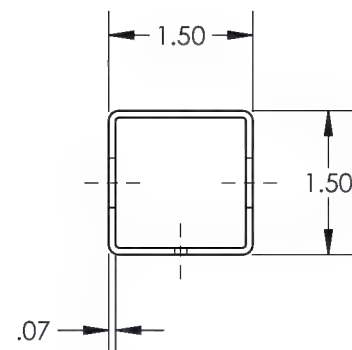
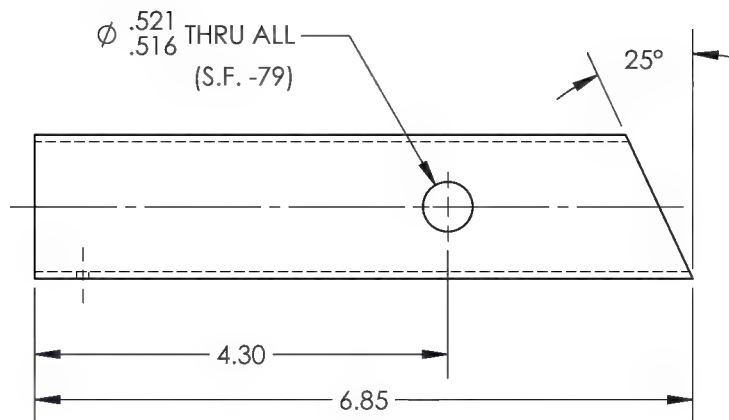
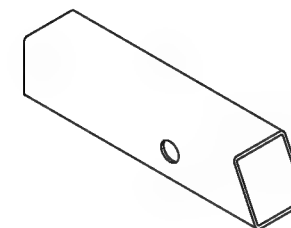
(-21)

BOTTOM TUBE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-21	REV 2
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -17 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 3/3/2016
SHEET 13 OF 30	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-23 CH'D DIM WAS Ø.526-.531 THRU ALL S.F. -79 IS Ø.516-.521 THRU ALL (S.F. -79)	9/13/2016	DPD	SM



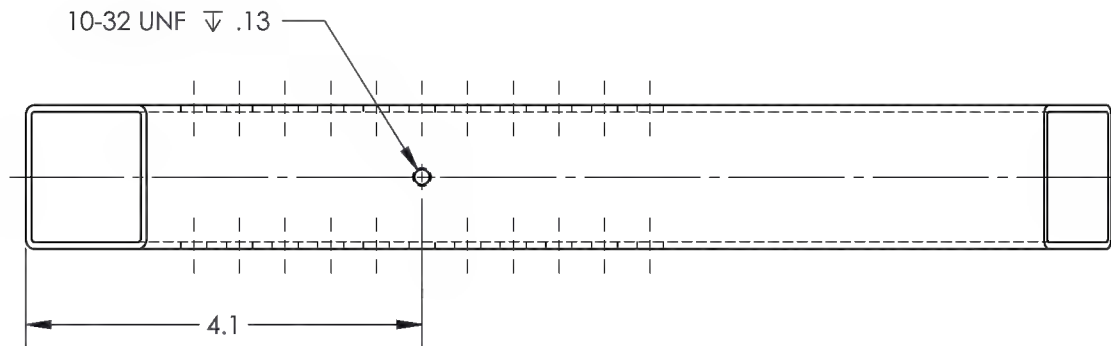
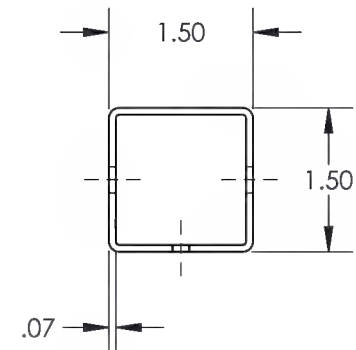
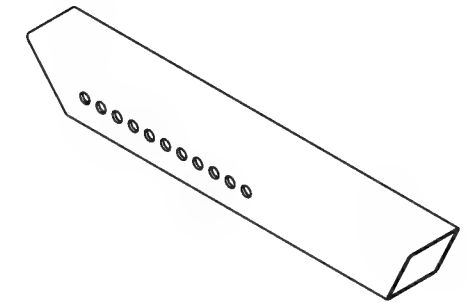
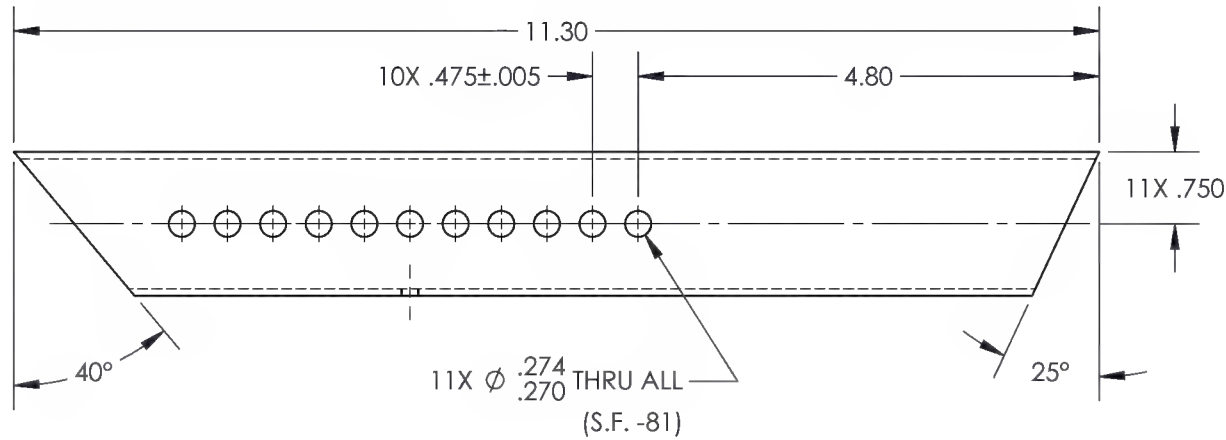
(-23)

BOTTOM UPRIGHT TUBE

DART AEROSPACE																															
TITLE MRB SLING																															
DWG NO. RBEM621V1006101-23	REV 2																														
<table border="1"> <tr> <td>MAT'L</td> <td>STEEL TUBE</td> <td rowspan="4"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓ </td> </tr> <tr> <td>HEAT TREAT</td> <td></td> </tr> <tr> <td>FINISH</td> <td>SEE -17</td> </tr> <tr> <td>SPEC</td> <td></td> </tr> <tr> <td>DRAWN BY:</td> <td>DUERFELDT</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED:</td> <td>CLOUGH</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR:</td> <td>ANDERSON</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR:</td> <td>LINDSAY</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED:</td> <td>GILBERT</td> <td>H175</td> </tr> <tr> <td>SCALE</td> <td>1:2</td> <td>DATE 3/3/2016</td> </tr> <tr> <td colspan="2"></td> <td>SHEET 14 OF 30</td> </tr> </table>		MAT'L	STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	HEAT TREAT		FINISH	SEE -17	SPEC		DRAWN BY:	DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR:	LINDSAY	USED ON MODEL	APPROVED:	GILBERT	H175	SCALE	1:2	DATE 3/3/2016			SHEET 14 OF 30
MAT'L	STEEL TUBE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓																													
HEAT TREAT																															
FINISH	SEE -17																														
SPEC																															
DRAWN BY:	DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																													
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING																													
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																													
QA APPR:	LINDSAY	USED ON MODEL																													
APPROVED:	GILBERT	H175																													
SCALE	1:2	DATE 3/3/2016																													
		SHEET 14 OF 30																													

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



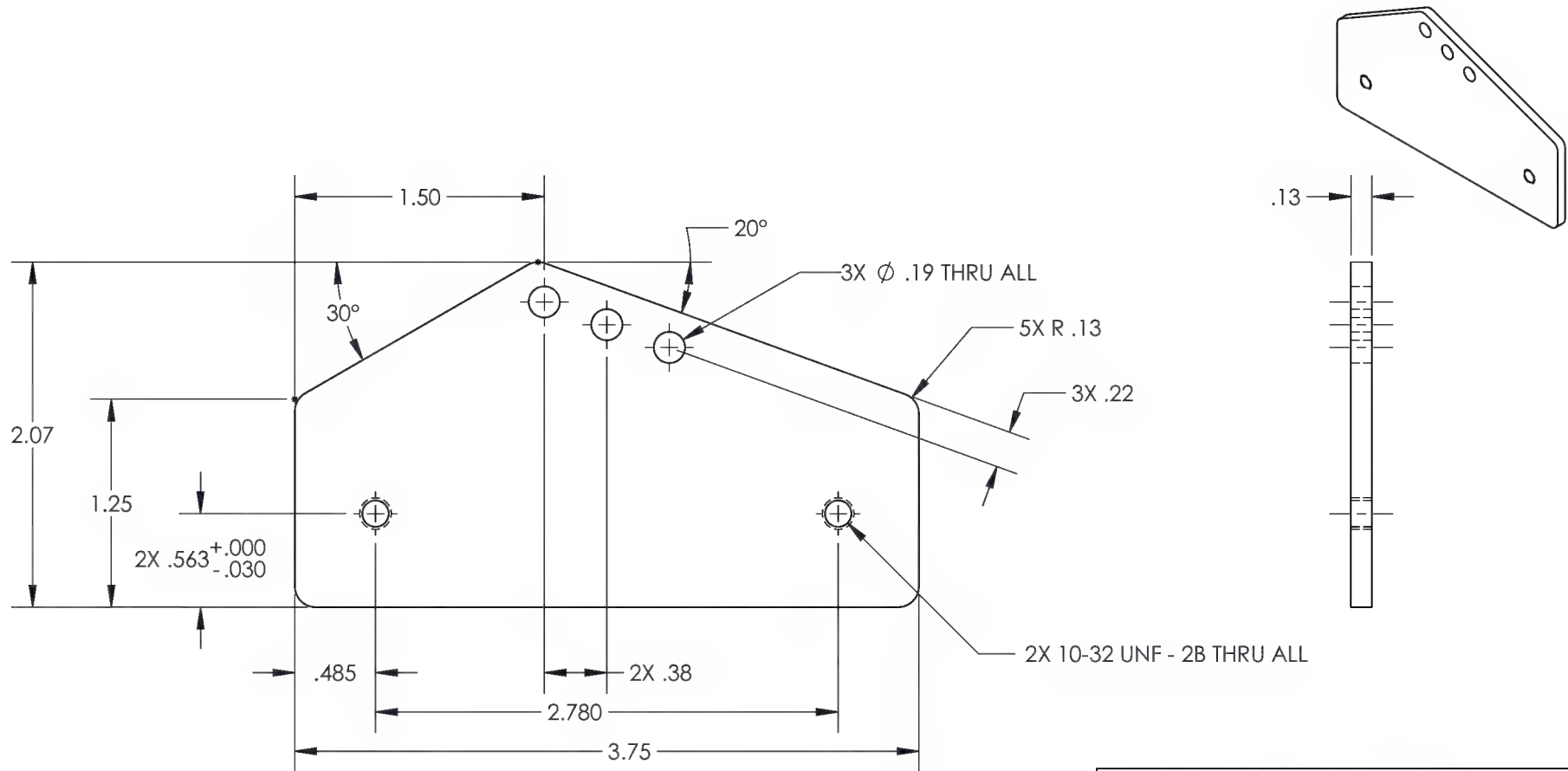
(25)

BOTTOM ANGLE TUBE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-25	REV 2
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -17 SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 3/3/2016
SHEET 15 OF 30	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



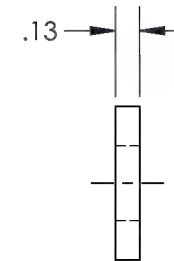
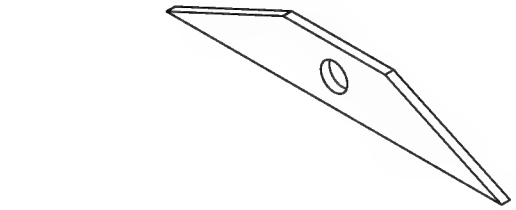
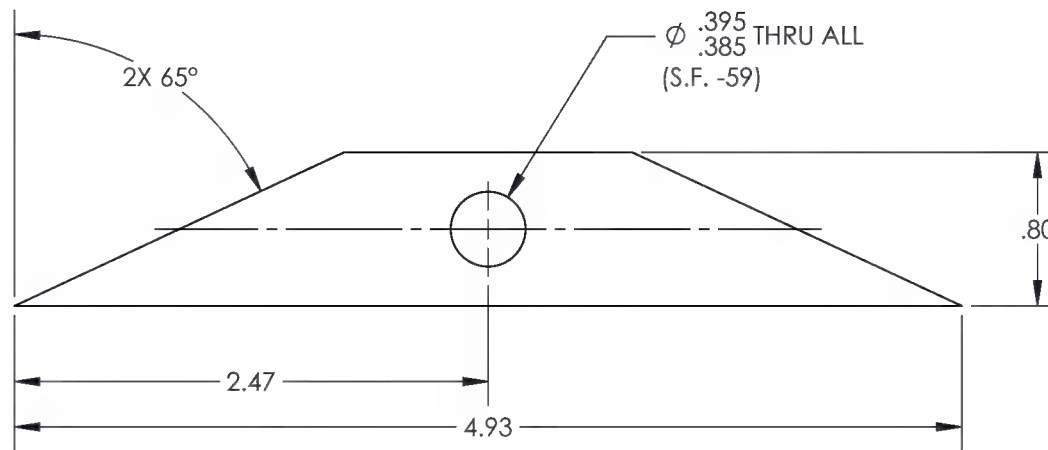
(27)

BOTTOM SPRING ANCHOR PLATE

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-27	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -17	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/3/2016
	SHEET 16 OF 30

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

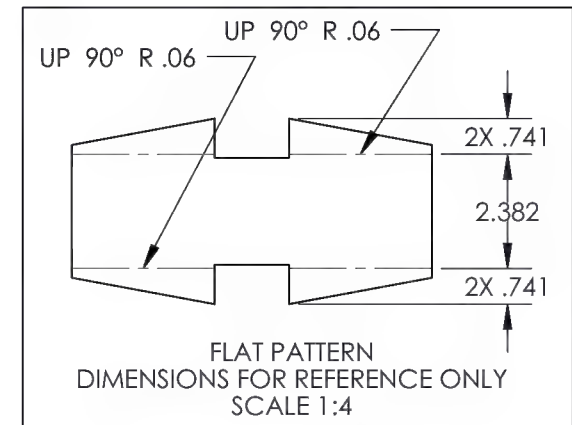
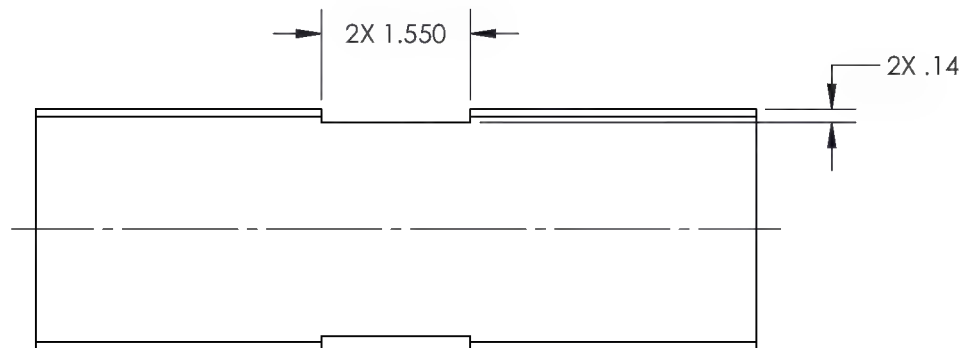
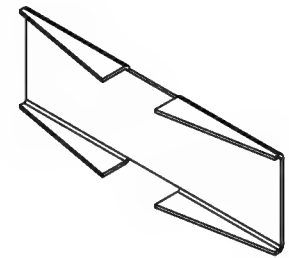
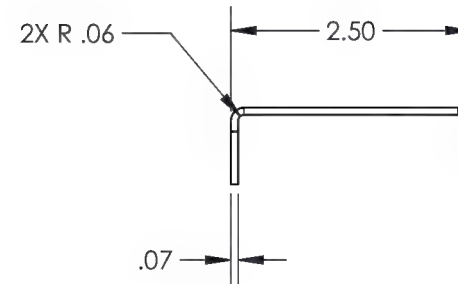
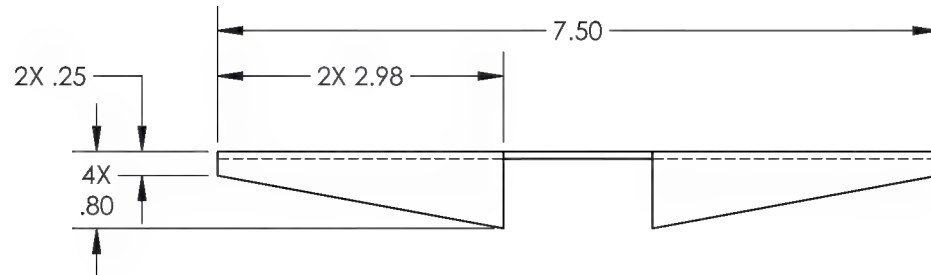


(-29)
STOP GUSSET

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-29	REV. 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -17	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 3/3/2016	USED ON MODEL
SHEET 17 OF 30	H175

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REVISIONS			
REV	ECR	DESCRIPTION	DATE INITIAL APPROVED



FLAT PATTERN
DIMENSIONS FOR REFERENCE ONLY
SCALE 1:4



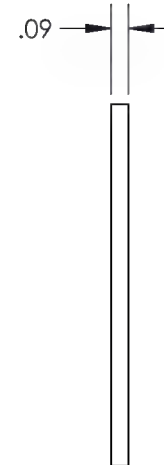
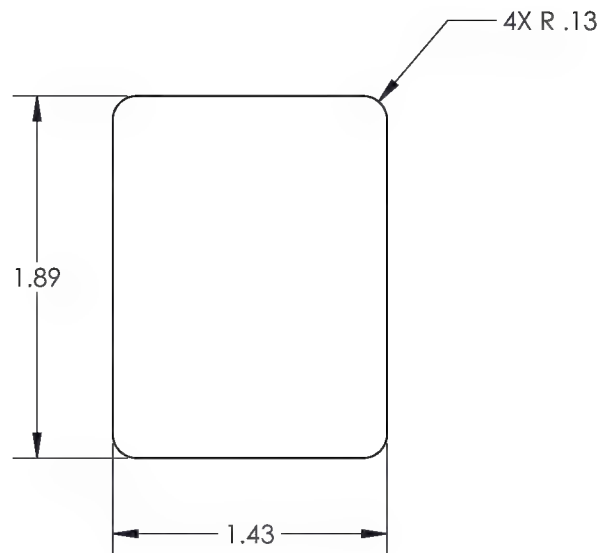
TITLE		MRB SLING	
DWG NO.		RBEM621V1006101-31	
REV		2	
MAT'L A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -17		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: DUERFELDT		.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 3/3/2016		USED ON MODEL	
SHEET 18 OF 30		H175	

(-31)

BOTTOM UPRIGHT SUPPORT

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



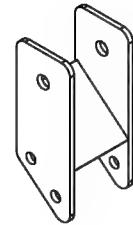
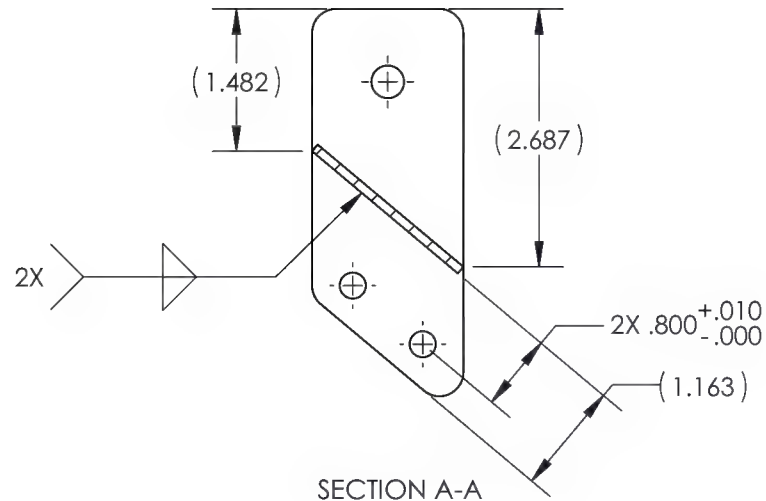
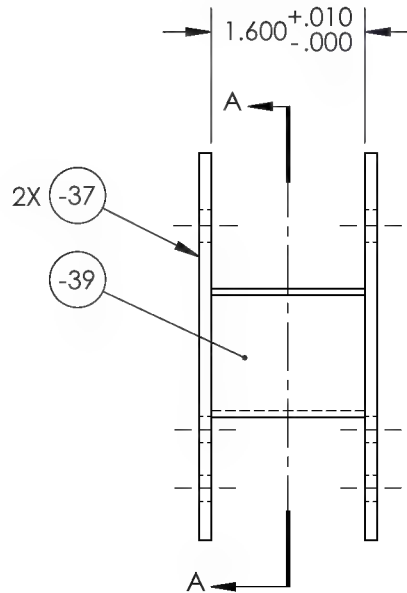
(-33)

LARGE TUBE CAP

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-33	REV 2
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -17	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/3/2016
	SHEET 19 OF 30

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-35 CH'D DIM WAS .800 +.010-.000 IS 2X .800 +.010-.000.	9/13/2016	DPD	SM



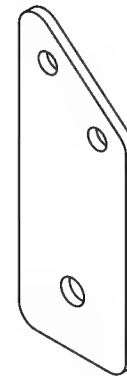
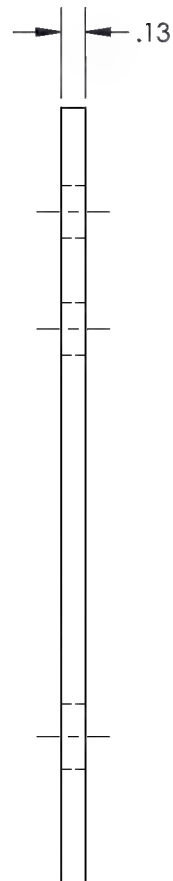
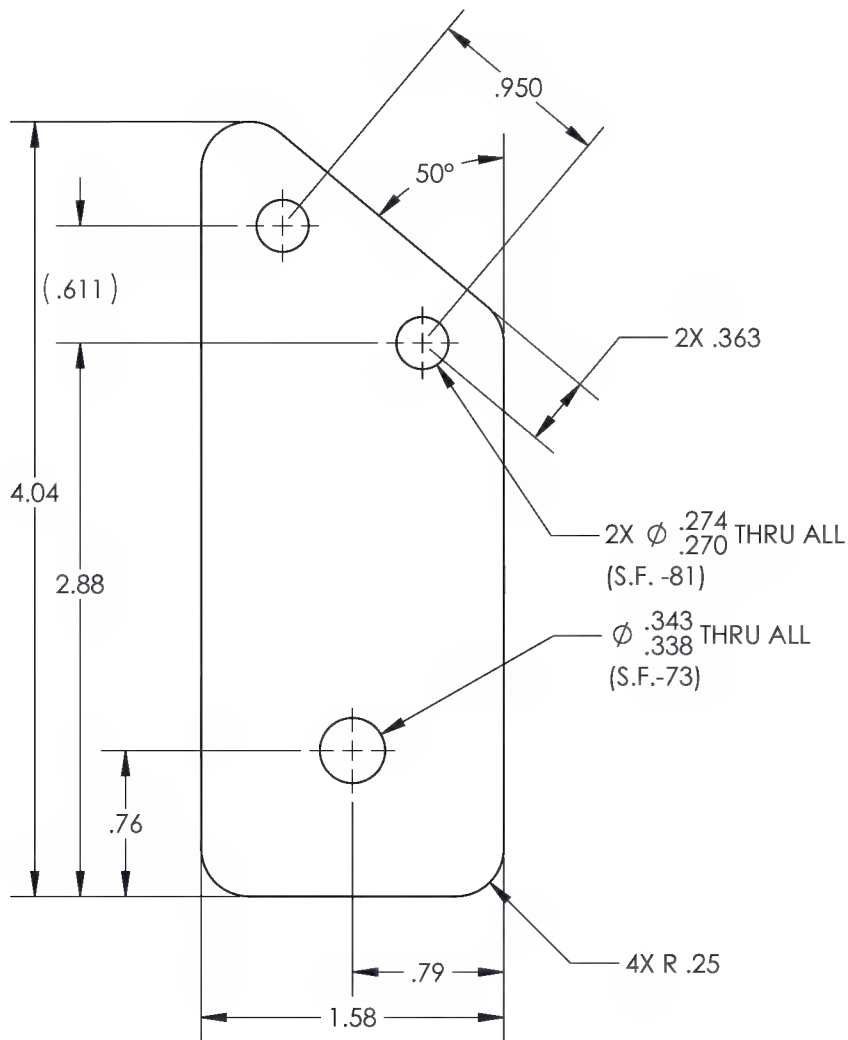
(-35)

LIFTING BLOCK WELDMENT

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-35	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .010 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .03 ANGLES ± 1°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125° ✓
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:2	DATE 3/3/2016
SHEET 20 OF 30	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-37 CH'D DIMS WAS .57 IS .76, WAS Ø.275-.280 THRU ALL S.F. -73 IS Ø.338-.343 THRU ALL (S.F. -73).	9/13/2016	DPD	SM



(-37)

LIFTING BLOCK PLATE



TITLE	
-------	--

MRB SLING

DWG NO.

RBEM621V1006101-37

REV
2

MAT'L	1018/1020 CR
-------	--------------

HEAT
TREAT

TREAT	
FINISH	SEE -35

SPEC

DRAWN BY:	DUERFELDT
-----------	-----------

CHECKED:	CLOUGH
----------	--------

OPPS APPR:	ANDERSON
------------	----------

QA APPR:	LINDSAY
----------	---------

APPROVED:	GILBERT
-----------	---------

SCALE	1:1
-------	-----

	UNLESS OTHERWISE SPECIFIED
--	----------------------------

DIMENSIONS ARE IN INCHES
XXX + .005 FRACTIONS + 1/8

.XXX	± .005	FRACTIONS ± 1/8
.XX	± .01	ANGLES ± .5°
X	± .1	SURFACES ± 1

1. BREAK ALL SHARP EDGES

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

	USED ON MODEL
--	---------------

	H175
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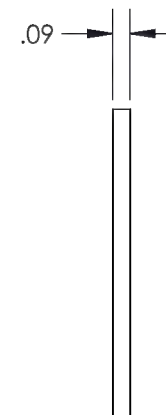
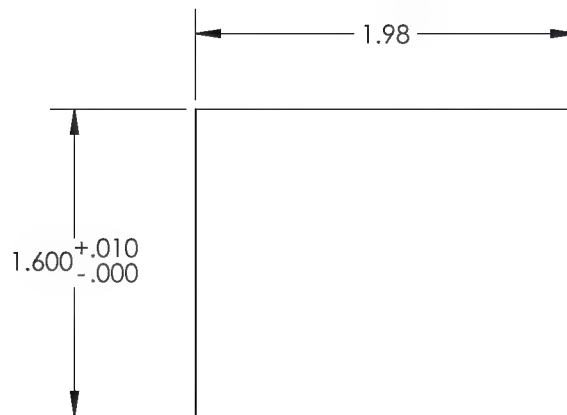
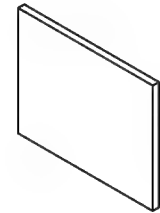
SCALE	1:1
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DATE	3/3/2016
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SHEET 21 OF 30

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



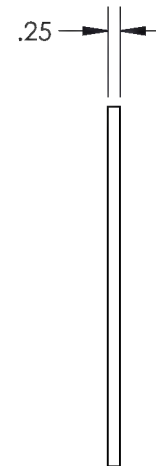
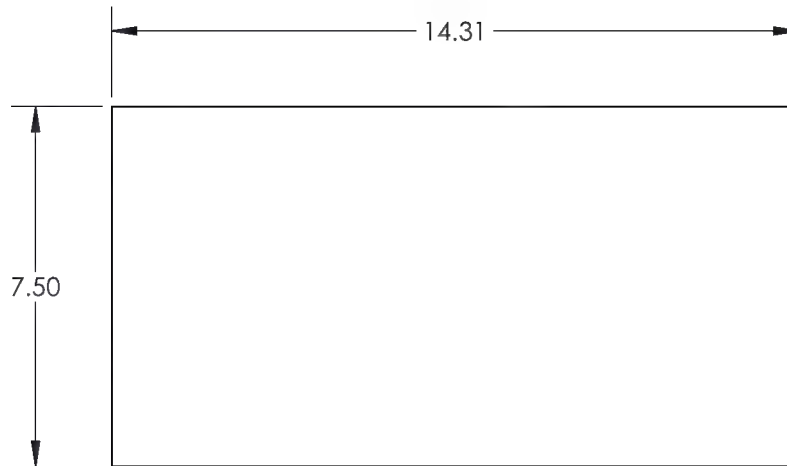
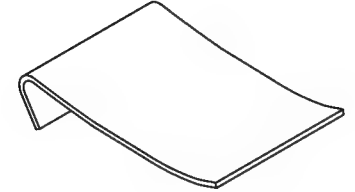
(-39)

LIFTING BLOCK SPACER

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-39	REV 2
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -35	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/3/2016
	SHEET 22 OF 30

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

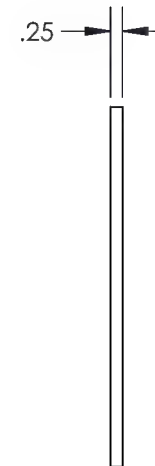
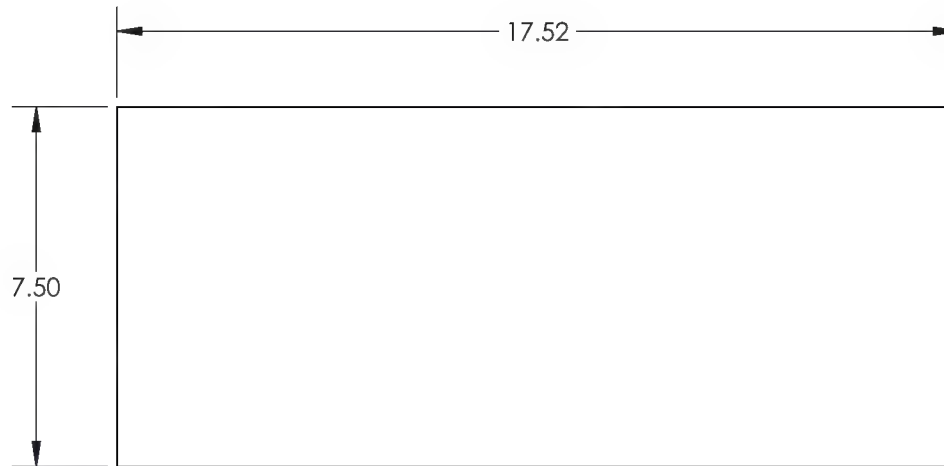
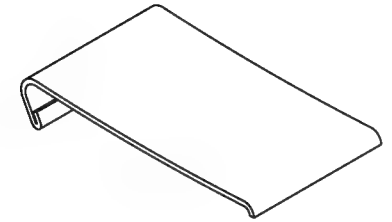


(-41)
TOP CLAMP PAD

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-41	REV 2
MAT'L NEOPRENE/EPDM/SBR FOAM TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL H175	
SCALE 1:4	DATE 3/3/2016
SHEET 23 OF 30	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



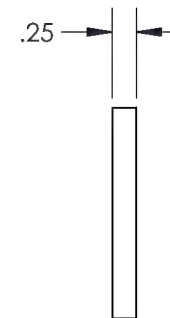
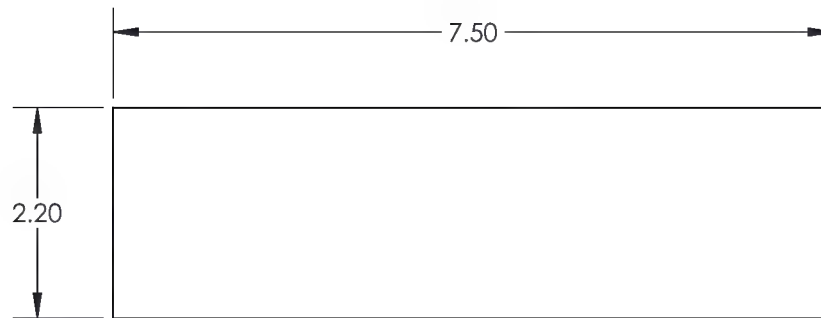
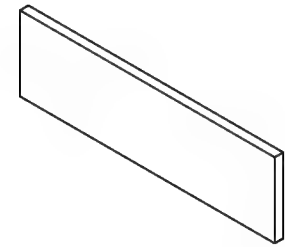
(-43)

BOTTOM CLAMP PAD

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-43	REV 2
MAT'L NEOPRENE/EPDM/SBR FOAM TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:4	DATE 3/3/2016
SHEET 24 OF 30	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



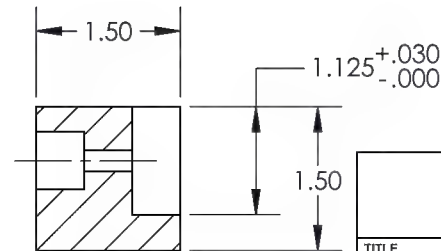
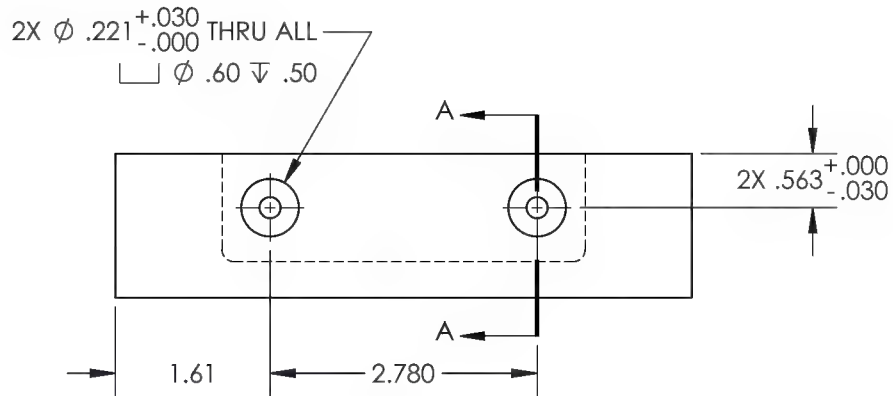
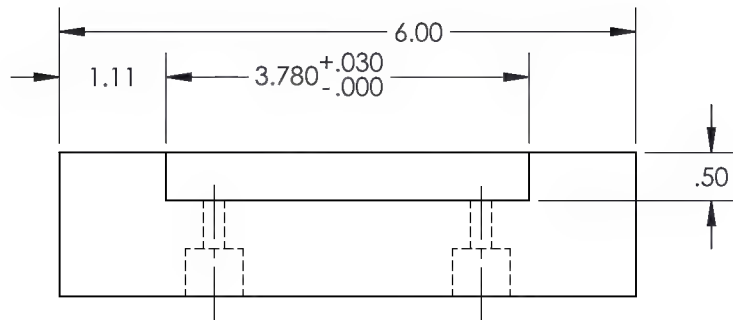
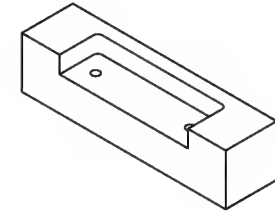
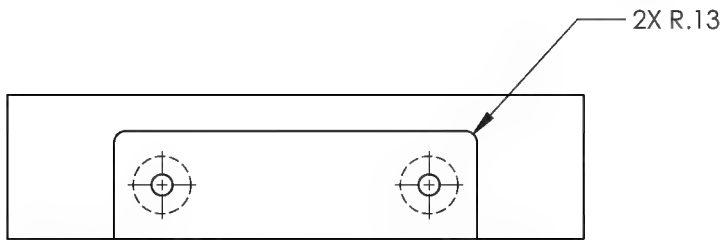
(-45)

BACK FOAM PAD

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-45	REV 2
MAT'L NEOPRENE/EPDM/SBR FOAM TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL H175	
SCALE 1:2	DATE 3/3/2016
SHEET 25 OF 30	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-47 ADDED DIM 2X R.13.	9/13/2016	DPD	SM



SECTION A-A

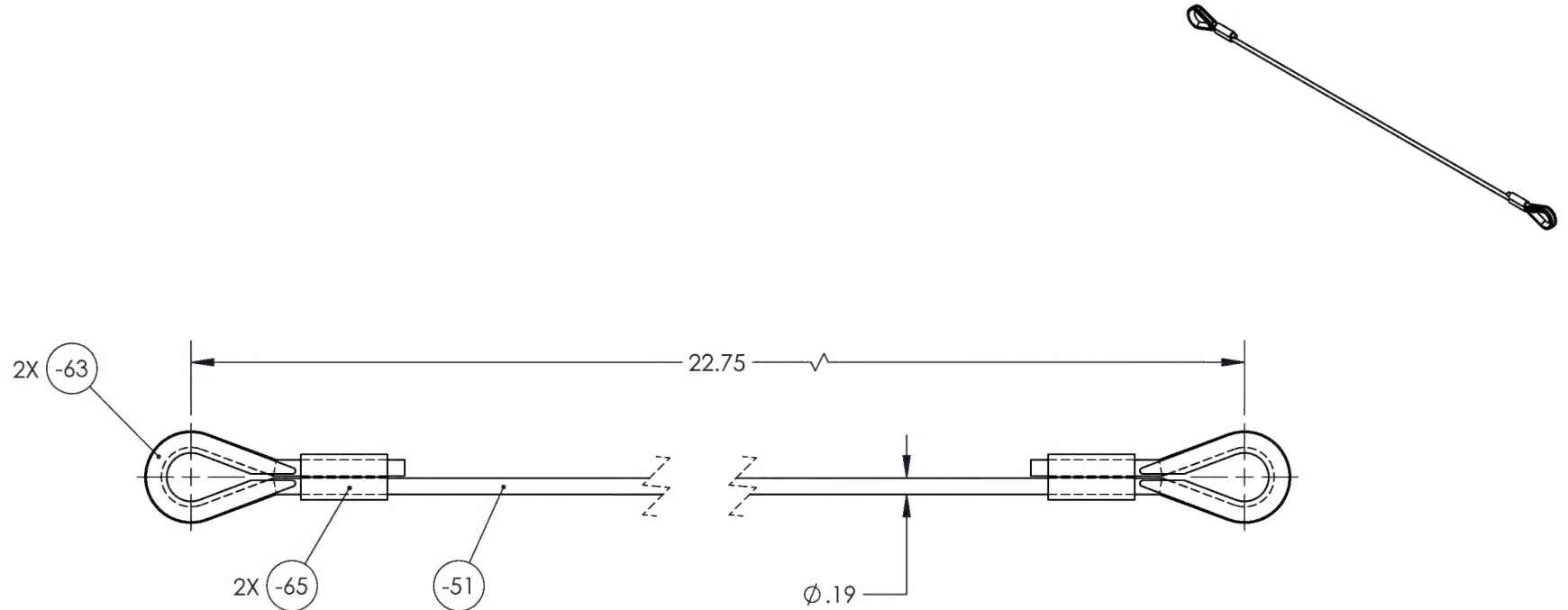
(-47)

REAR BUMPER

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-47	REV 2
MAT'L URETHANE, 60A TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 3/3/2016
SHEET 26 OF 30	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



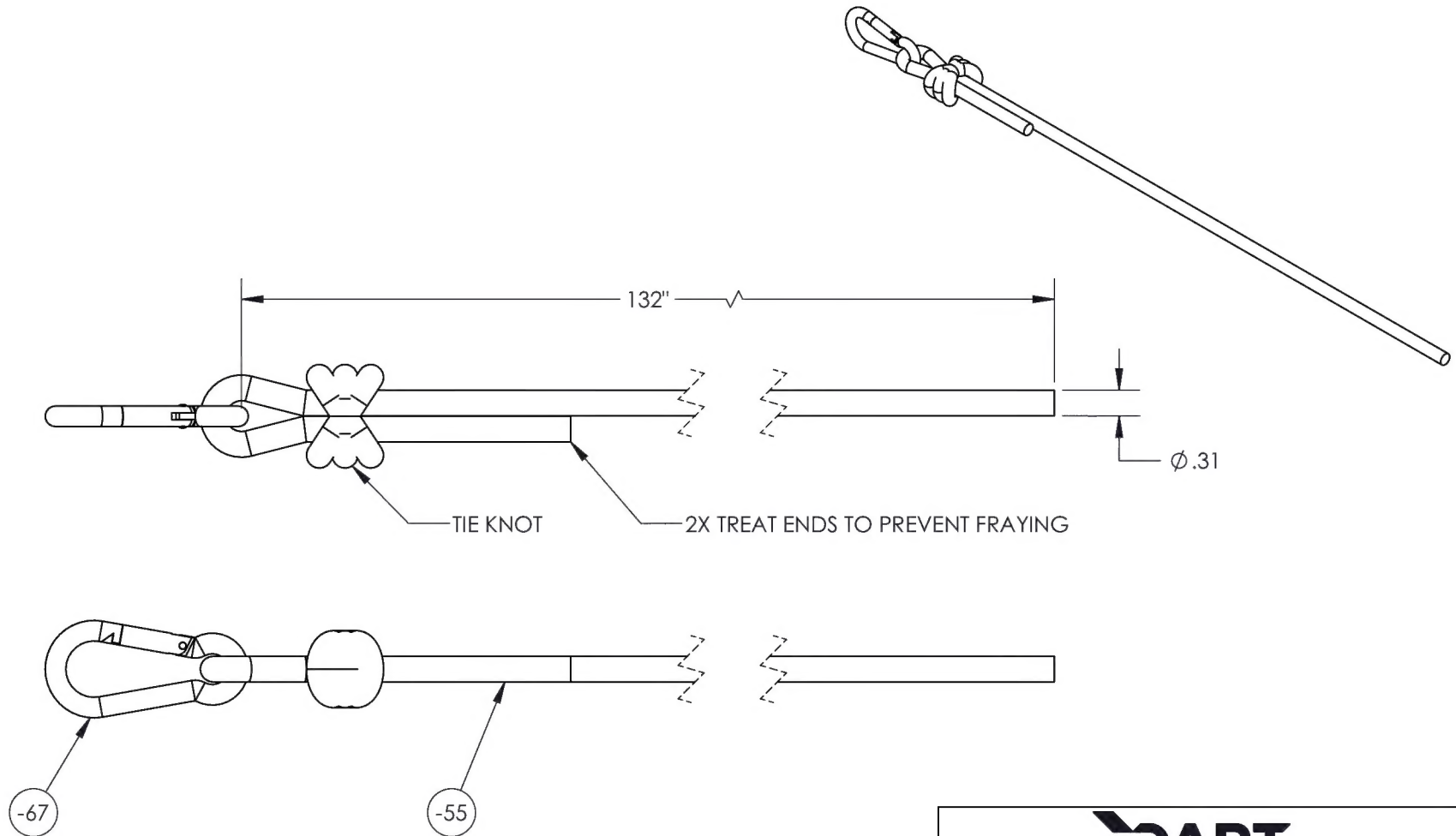
(-49)

LIFTING CABLE ASSEMBLY

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-49	REV 2
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/3/2016
SHEET 27 OF 30	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

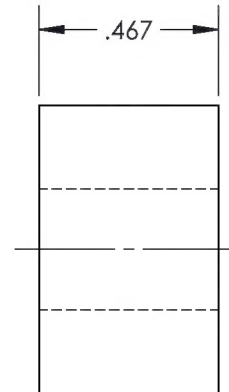
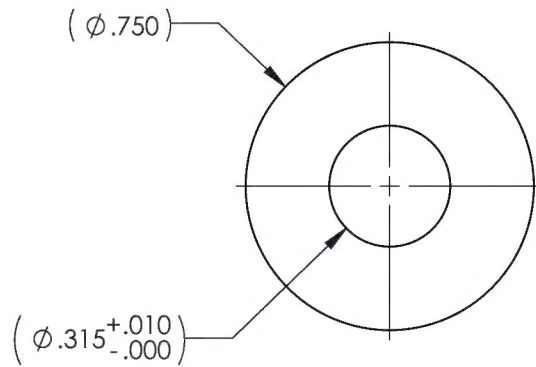
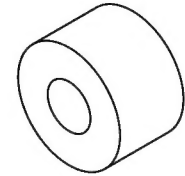


ROPE & CARABINER ASSEMBLY

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-53	REV 2
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 3/3/2016
SHEET 28 OF 30	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0147	-57 CH'D DIMS WAS (Ø.625) IS (Ø.750). WAS (Ø.252 +.010-.000) IS (Ø.315 +.010-.000), WAS .537 IS .467.	9/13/2016	DPD	SM

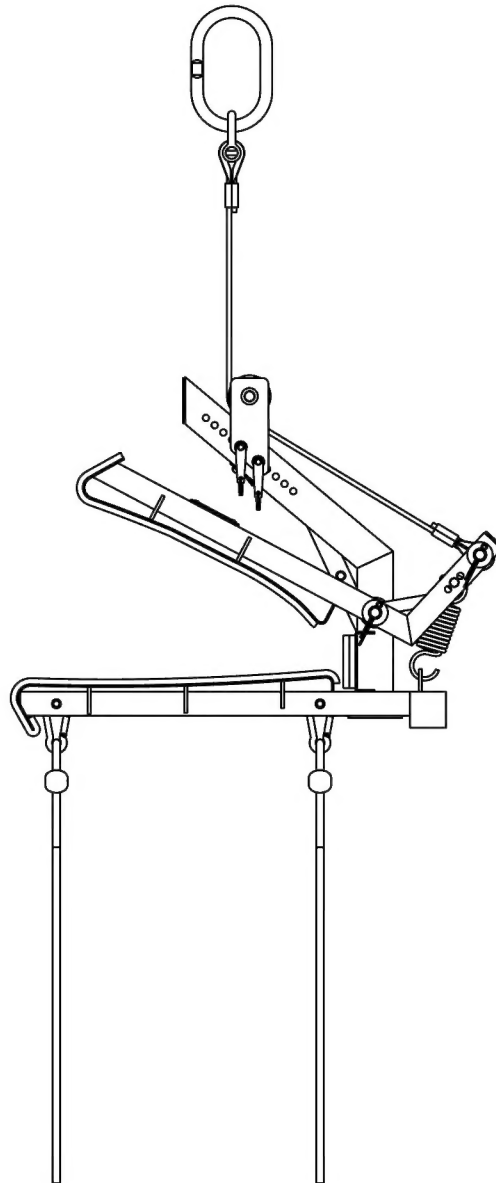


(-57)

SPACER

DART AEROSPACE	
TITLE MRB SLING	
DWG NO. RBEM621V1006101-57	REV 2
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 2:1	DATE 3/3/2016
	SHEET 29 OF 30

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FIRST ARTICLE WEIGHT TEST

INSPECTION & TESTING PROCEDURES FOR THE RBEM621V1006101, MRB SLING.

THIS ASSEMBLY IS DESIGNED TO LIFT A MAIN ROTOR BLADE. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE 330 LBS. IN MRB SLING. LIFT MRB SLING USING AN APPROPRIATE LIFTING DEVICE, FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT TOOL, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.

INSPECTOR: _____

TESTER: _____

S.N.: _____

DATE: _____



190 S. Danebo Ave., Eugene, OR. 97402
1-800-556-4166
e-mail: sales@dartaero.com
dartaerospace.com

TITLE			
MRB SLING			
DWG NO.	REV		
RBEM621V1006101	2	CUSTOMER 1 OF 1	
SCALE	1:8	DATE	3/3/2016
		SHEET	30 OF 30